

5/44

DART AEROSPACE LTD	Work Order:	24267
Description: Bracket Assembly	Part Number:	D3121-141
Dwg: D3121 Rev. C	Qty:	9 Kit(s) Page 1 of 1

HT
04.02.27
kg

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	(S)	05.09.14	9
2	MV	Cut blanks: (1.000" x 2.000") 6.600" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-111			
3	MV	Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111	BG/ AB	05/10/16	9
4	QC2	Inspect parts as they come off the CNC machine	BG/ AB	05/10/11	9
5	MV	Deburr	BG/ AB	05/10/11	9
6	MV	Scribe batch number	BG/ AB	05/10/11	9
7	QC8	Second check	SP	05/10/12	9
8	GA	Assemble D3121-141 as per Dwg D3121. Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 1 D3121-21 Bolt BZ3914 1 D3121-241 Bearing Assembly BZ18559 Identify as D3121-141			
9	QC5	Inspect work to Step 8	ML	05/10/17	9
10	ST	Identify and Stock	CD	05/10/19	9
11	AC	Cost / part _____			
12	DC	Close W/O Inspect Level 21	(D)	05/11/23	9

Rev	Date	Change	Revised By	Approved
AB	04.02.18	New issue	KJ/DS	HT

PF 04.02.19

RELEASED
04.02.19 HT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/11	3	the spigot its to big he have two flat	SB QSI42	Scrap & destroy and replace	MS 05/10/11	SB 05-10-11	SB QSI42	SB 05/10/11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/11/11

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24267
Description: Bracket	Part Number:	D3121-111
Inspection Dwg: D3121	Rev: C2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.392.	✓			To fit bearing
0.75	+/-0.030	.753	✓			
0.375	+/-0.010	.371	—			
2.14	+/-0.030	2.128	✓			
0.950	+/-0.010	.947	✓			
0.600	+/-0.010	.605	✓			
1.96	+/-0.030	1.965	—			
0.280	+/-0.010	.283	✓			
3.330	+/-0.010	3.320	✓			
3.630	+/-0.010	3.633	✓			
R0.25	+/-0.030	.250	✓			
R0.375	+/-0.010	.375	—			
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
6.18	+/-0.030	6.177	—			
5.89	+/-0.030	5.897	—			
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.299	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	.250	✓			
0.130	+/-0.010	.128	✓			
0.381	+/-0.010	.380	✓			
0.201	+/-0.010	.202	—			
0.400	+/-0.010	.398	—			
0.580	+/-0.010	.580	✓			
100°	+/-0.1°	100°	✓			
0.032 0.32	+/-0.010	.032	✓			

Measured by:	SG	Audited by:	SD	Prototype Approval:	N/A
Date:	05.10.09	Date:	05.10.09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	JL